

Work Order ID 60853

Monday, July 26, 2010 10:43:11 AM



Page 1

Item ID: D2876

Accept



Setup Start



Revision ID:

Item Name: Saddle Spacer

Stop



Start Date: 7/26/2010 Start Qty: 20.00



Cust Item ID:

Required Date: 8/3/2010 Req'd Qty: 20.00

Customer:

Reference:

Approvals:

Process Plan:

M

Date: 10-7-24

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2876

Rev B

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D 2876 ☐ Dwg Rev: B ☐ Prog Rev: B ☐ 2-
Deburr if necessary

6061 -100

KB 10-7-28

(49)

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

KB 10-7-28

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

S10608103

counts
(X49)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle Spacer

Start Date: 7/26/2010 Start Qty: 20.00



Cust Item ID:

Required Date: 8/3/2010 Req'd Qty: 20.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	Small Fab	0.00							
Small Fab	Memo	0.00							
Small Fab	Remove tabs and Tumble								
140 	Chemical Conversion Coat per QSI005 4.1	0.00							
HandFinish	Memo	0.00							
Hand Finishing									
150 	QC3- Inspect Part Finish	0.00							
QC	Memo	0.00							
Quality Control									

u/25

ul 10/08/0-1

49 0

49 BK 10-8-3

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Item ID: D2876

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle Spacer

Start Date: 7/26/2010 Start Qty: 20.00



Cust Item ID:

Required Date: 8/3/2010 Req'd Qty: 20.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



Packaging

Identify as per dwg & Stock Location: *26*

0.00

Memo

0.00

170



QC

Quality Control

QC21 - Final Inspection - Work Order Release

0.00

Memo

0.00

*10/8/11**492 SP**10/08/04**10-8-04**49*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Monday, July 26, 2010 10:43:15 AM

Page 1

Work Order ID: 60853

Parent Item: D2876

Parent Item Name: Saddle Spacer



Start Date: 7/26/2010

Start Qty: 20.00

Required Date: 8/3/2010

Required Qty: 20.00

Comments: Esr Rev:B 00.05.19 Added inspect level 8 EC
IPP Rev:C Now M6061-T6 06-06-23 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M6061T6S.100

Purchased

No

100

sf

79.0788

0.0516

1.086316

2.6



6061-T6 .100 Sheet



810-7-28

Location

Loc Qty

Loc Code

MAT21

42

102201

42

MAT5

37.07877902

102201

37.0787790

102201

49

W/O:		WORK ORDER CHANGES						
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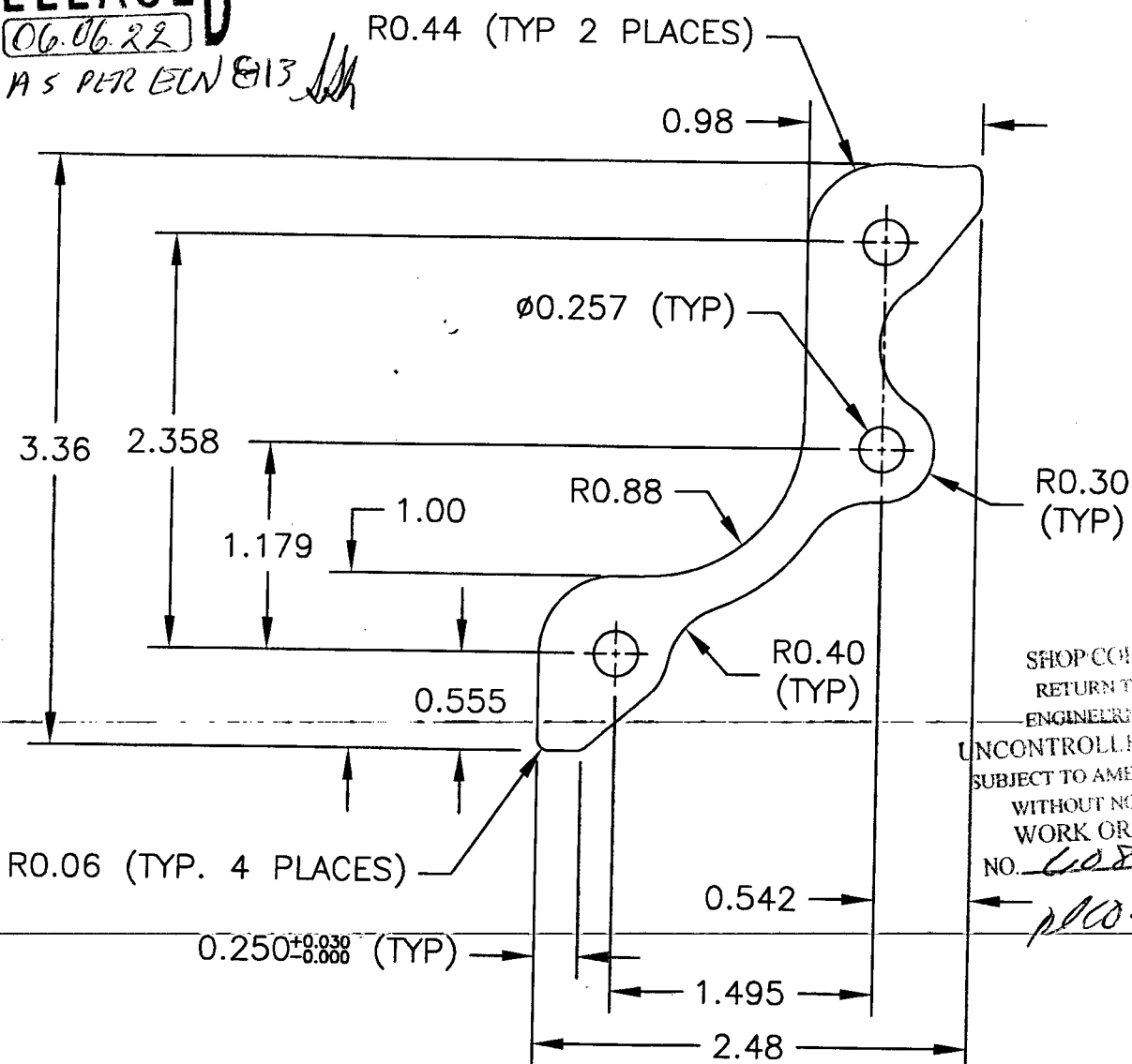
DART

DESIGN <i>CP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2876	REV. B SHEET 1 OF 1
DATE 06.06.02		TITLE SADDLE SPACER	SCALE 1:1
A	99.02.23	NEW ISSUE	
B	06.06.02	MATERIAL CHANGE	

RELEASED

06.06.22

AS PER ECN 813

**NOTES:**

- 1) MATERIAL: 6061-T6 ALUMINUM SHEET (QQ-A-250/11) 0.100" THICK
(REF DART SPEC M6061T6S.100)
OR
5052-H32/H34 ALUMINUM SHEET (QQ-A-250/8) 0.100" THICK
(REF DART SPEC M5052H32S.100)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) ALL DIMENSIONS ARE IN INCHES

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